

Date: Wednesday, 9/13/2006 4:14:24 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206B STEP ASSY, RH
Job Number	: 28504A		
Estimate Number	: 11699		
P.O. Number	: <i>N/A</i>	Part Number	: D2721042
This Issue	: 9/13/2006	Drawing Number	: D2721 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i>	Drawing Revision	: C
Previous Run	: 26714A	Material	: <i>PM</i>
Written By	: <i>[Signature]</i>	Due Date	: 10/5/2006
Checked & Approved By	: <i>[Signature]</i> 06.09.14	Qty:	3 Um: Each
Comment	: Est Rev:F As Per Ecn 766 06-01-06 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2622120C	Extrusion
-----	-----------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	<i>B28215 = 3</i>

Check Material for any Dents or Defects

PE 06.10.12 3

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------

**Comment:** LARGE FABRICATION RESOURCE 1

Cut D2721-2 using D2622 extrusion as per Dwg D2721
 Deburr and bevel ends for welding

PE 06.10.12 3
PE 06.10.12 3

3.0	D2734	206 Step Endplate
-----	-------	-------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	<i>B27281</i>

4.0	D34611	PLATE
-----	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

206 Step Lug

Pick:

Qty	Part Number	Description	Batch
1	D3461-1	Plate	<i>B26311 = 3</i>

PE 06.10.12 3

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/13/2006 4:14:24 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B STEP ASSY, RH

Job Number: 28504A

Part Number: D2721042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34613

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3461-3	Plate	<u>326312</u> = 3

P.E. 06.10.12

3

6.0

D34615

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3461-5	Plate	326313 <u>326313</u> = 3

P.E. 06.10.12

3

7.0

D34617

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3461-7	Plate	<u>326314</u> = 3

P.E. 06.10.12

3

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap (One End Only) and lugs as per Dwg D2721 using Jig DT

followed by Jig DT

P.E. 06.10.12

3

A/R AL Rod Batch:

~~AMR~~
M19612 E M18838

P.E. 06.10.12

3

Grind end cap welds flush

P.E. 06.10.13

3

9.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

Job 10.16 (3)

10/10/16 (3)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/13/2006 4:14:25 PM
User: Kim Johnston

SHIP 25/10
Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B STEP ASSY, RH

Job Number: 28504A

Part Number: D2721042

Job Number:



Seq. #: Machine Or Operation: Description :

10.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

~~10/16/06~~ 06/10/16 (3)

11.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PE. 06.10.17 3

12.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

Weld Remaining end cap as per Dwg D2721 using Jig DT followed by Jig DT

A/R AL Rod Batch: M1883B

Grind End Cap Welds Flush

PE. 06.10.17 3
PE. 06.10.17 3
PE. 06.10.17 3
PE. 06.10.17 3

13.0 QC5/9 WELD INSPECTION



Comment: WELD INSPECTION

PE. 10.17 (3)
06/10/18 (3)

14.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch Up Alodine

FC 06 10 23 (3)

15.0 POWDER COATING POWDER COATING



Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M101575
FC 06 10 23 (3)

16.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06/10/24 (3)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: AD Date: 06/18/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Wednesday, 9/13/2006 4:14:25 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B STEP ASSY, RH

Job Number: 28504A

Part Number: D2721042

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D2721 and QSI 00 5 4.4

YH

06/10/24

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

P

(3)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

NP

20.0

QC21

FINAL INSPECTION/W/O RELEASE



(3)

Comment: FINAL INSPECTION/W/O RELEASE

P

06/10/24

Job Completion



W 06-10-24

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

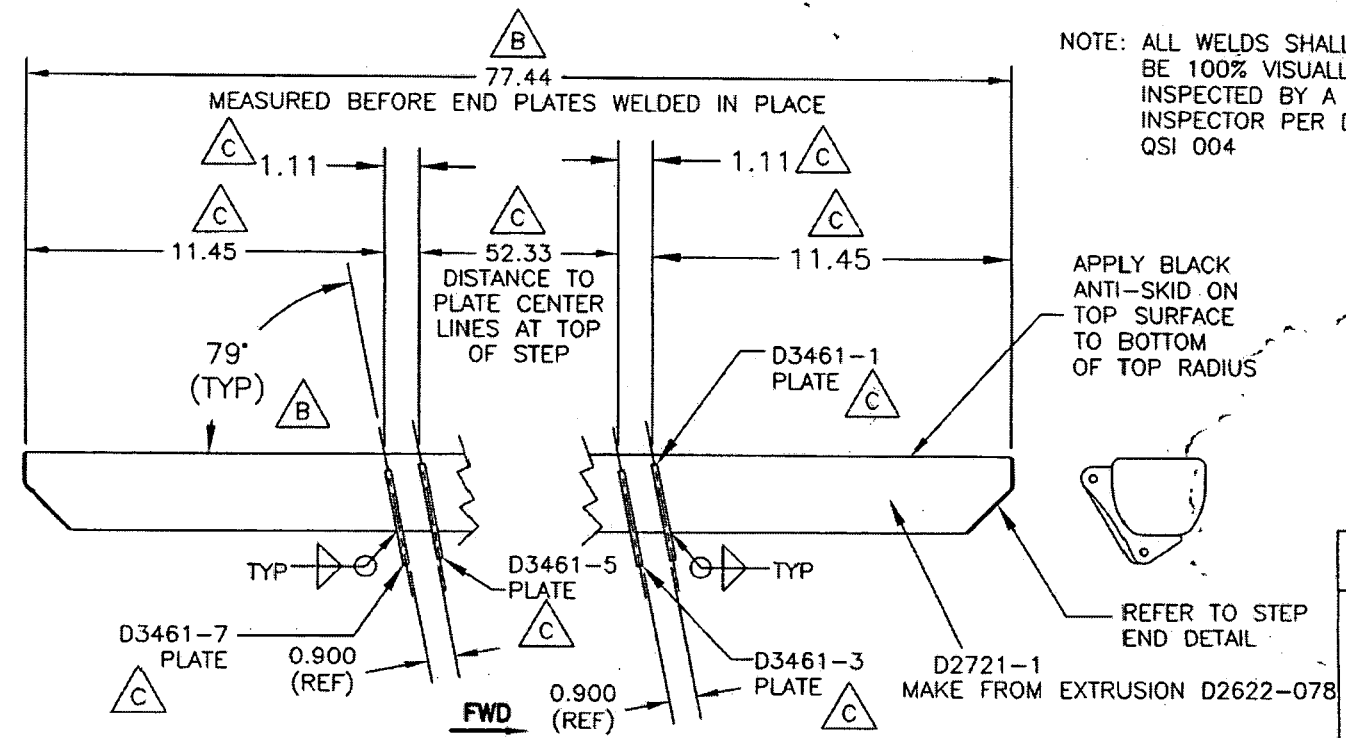
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

DART

RELEASED
05:11:14

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004



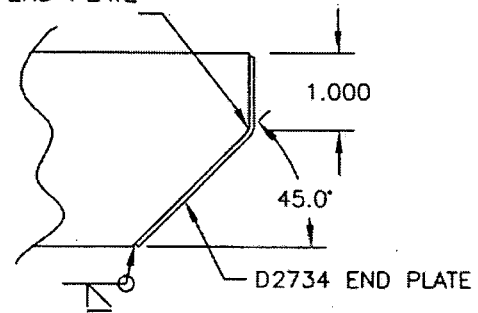
D2721-041 LH STEP ASSEMBLY (SHOWN)
D2721-042 RH STEP ASSEMBLY (OPPOSITE)

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE

D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X	X	D2721-041	LH STEP ASSEMBLY
		D2721-042	RH STEP ASSEMBLY
1	1	D2622-078	EXTRUSION
2	2	D2734	END PLATE
1	1	D3461-1	PLATE
1	1	D3461-3	PLATE
1	1	D3461-5	PLATE
1	1	D3461-7	PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO. 28504A



TYPICAL STEP END DETAIL

D2721-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	05.09.19	TITLE	206B STEP ASSEMBLY	REV. C
A	97.12.04	NEW ISSUE		SHEET 1 OF 1
B	98.10.19	79° WAS 80°, UPDATED WELD DETAIL REVISED TOLERANCES, 53.44 WAS 54.0		SCALE
C	05.09.19	RE-DESIGN, ADD D3461-1/-3/-5/-7		NTS

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Date: Wednesday, 9/13/2006 4:14:07 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206 A/B STEP ASSEMBLY RH
 Job Number : 28504
 Estimate Number : 11115
 P.O. Number : *N/A* Part Number : D206628012
 This Issue : 9/13/2006 S.O. No. : *N/A* Drawing Number : N/A
 Prsht Rev. : NC Project Number : N/A
 First Issue : *N/A* Type : LARGE FAB ASSY Drawing Revision : N/A
 Previous Run : 26714 Material : *N/A*
 Due Date : 10/5/2006 Qty: 3 Um: Each
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]* 06.09.14
 Comment : Est Rev:D As Per Ecn 766 06-01-06 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-012 CHG 002

06-09-19 *KS* (3)

2.0 28504A 206B STEP ASSY, RH



Comment: Sub-Component SUB-ASSEMBLY

206B STEP ASSY, RH

D2721-042 B *B28504A*

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

06/10/23 (3)

4.0 D27311 Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

✓ Qty Part Number Description Batch
 2 D2731-1 Mounting Lug *B20613 smcy*
9444 /mcy

5.0 D27317 Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

✓ Qty Part Number Description Batch
 2 D2731-7 Mounting Lug *B25452*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B STEP ASSEMBLY RH

Job Number: 28504

Part Number: D206628012

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2856400

Abrasion Strip



Comment: Qty.: 1.1708 f(s)/Unit Total : 3.5123 f(s)

Pick :

Qty	Part #	Description	Batch
✓ 2	D2856-400 6.9"	Abrasion Strip	B28258

7.0

D2856400

Abrasion Strip



Comment: Qty.: 0.5460 f(s)/Unit Total : 1.6380 f(s)

Pick :

Qty	Part #	Description	Batch
✓ 2	D2856-400 6.25"	Abrasion Strip	B28258

8.0

D3394041

LUG ASSY



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
✓ 2	D3394-041	LUG ASS,Y	B25407

9.0

D3394043

LUG ASS'Y



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
✓ 2	D3394-043	LUG ASS,Y	B28485 → ASS'Y

10.0

AN415A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
✓ 4	AN4-15A	Bolt	M102039

11.0

AN411A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
✓ 4	AN4-11A	Bolt	M100793

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☒ DQA: DP Date: 06/18/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Wednesday, 9/13/2006 4:14:07 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B STEP ASSEMBLY RH

Job Number: 28504

Part Number: D206628012

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN412A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

✓ 4 AN4-12A Bolt M101390

13.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick:

Qty Part Number Description Batch

✓ 12 AN960JD416 Washer M19185 SURT 1 31.50

RES TO 96 MEX ST-CH
PAS-STAR

14.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick:

Qty Part Number Description Batch

✓ 12 MS21042L4 Nut (or MS21042-4) M19099 -

Pu/pu 12 3 (3)

15.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

U3 06/10/23 (3)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-012

Location:

PPP Rev: E

Pu/pu 124 (3)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

U 06/10/24

Job Completion



U 06.10.24

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

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